

Work Order ID 111863

Thursday, January 23, 2014 4:11:49 PM

111863

Page 1

Item ID: D4634-145 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft, Center Ceiling Replacement Panel Assembly
 Start Date: 1/23/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/29/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: ✓ Date: 14-01-23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4634	E

100 0.00
100
 Hand Thermo Memo 0.00 ① SAD 14/01/27
 Hand Finishing Thermoforming Pick Kit

110 0.00
110
 Small Fab Memo 0.00 ① SAD 14/01/28
 Small Fab Assemble as per Dwg D4634-145 Scotch - Weld 1300L B# m127913

1- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.

Batch # m127913

Expiry Date 7/10/2014

2- Apply labels as per Dwg. and seal with 3M 3950 edge sealer B# m124725

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Item ID: D4634-145 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft, Center Ceiling Replacement Panel Assembly
Start Date: 1/23/2014 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 1/29/2014 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 SAP 14/1/28				1			
125 *125* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 SAP 14/1/28				1			
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>med Fab</u> Memo	0.00 0.00				①	SAP	14/01/28	

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Item ID: D4634-145

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Aft, Center Ceiling Replacement Panel Assembly

Stop ***NS2***Start Date: 1/23/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/29/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 14-01-29

H 14-01-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Work Order ID: 111863

111863

Parent Item: D4634-145

D4634-145

Parent Item Name: Aft, Center Ceiling Replacement Panel Assembly

Start Date: 1/23/2014

Required Date: 1/29/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A New Issue 13/02/05 DL VERIFIED BY:JLM IPP Rev.
B Dwg.Update 13/07/09 DL verf: DD IPP Rev C Dwg Update
remove channels add foam 13/12/23 DL IPP REV D 14/01/20 Dwg Update
DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4636-5

Manufactured

No

100

Each

36.0000

1

1

D4636-5

Bracket

**

SAD 14/01/27

Location

Loc Qty

Loc Code

ST115

36

111230

36

D4712-1

Manufactured

No

100

Each

10.0000

1

1

D4712-1

Bracket

**

SAD 14/01/27

Location

Loc Qty

Loc Code

prelim

2

110411

2

ST121

8

111162

8

D5021-5

Manufactured

No

100

Each

1.0000

1

1

D5021-5

Foam, Center Panel, Aft

**

SAD 14/01/27

Location

Loc Qty

Loc Code

prelim

1

111352

1

Picklist Print

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Work Order ID: 111863

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Parent Item: D4634-145

D4634-145

Parent Item Name: Aft, Center Ceiling Replacement Panel Assembly

Start Date: 1/23/2014

Required Date: 1/29/2014

Start Qty: 1.00

Required Qty: 1.00

MS20426AD3-4

Purchased

No

100

Each

10,559.00

4

4

MS20426AD3-4

RIVET

**

SAD 14/01/27

Location

Loc Qty

Loc Code

ST334

4000

m127432

4000

ST509

6559

125578

6559

MS20426AD4-6

Purchased

No

100

Each

3,086.000

2

2

MS20426AD4-6

Rivet

**

SAD 14/01/25

Location

Loc Qty

Loc Code

GA

1582

m126474

1582

ST334

1504

124392

1504

MS21059L08

Purchased

No

100

Each

1,112.000

2

2

MS21059L08

Nut

**

SAD 14/01/27

Location

Loc Qty

Loc Code

ST508

1112

125654

1112

D4634-5

Manufactured

No

100

Each

0.0000

1

1

D4634-5

Aft, Center Ceiling Panel

**

B 111170

SAD 14/01/27

Picklist Print

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Work Order ID: 111863

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Parent Item: D4634-145

D4634-145

Parent Item Name: Aft, Center Ceiling Replacement Panel Assembly

Start Date: 1/23/2014

Required Date: 1/29/2014

Start Qty: 1.00

Required Qty: 1.00

D4647-1

Manufactured No

100 Each

13.0000

1

1

D4647-1

Doubler

**

SAD 14/01/27

Location

Loc Qty

Loc Code

ST116

13

104796

6

111234

5

95871

2

D4664-5

Manufactured No

100 Each

64.0000

6

6

D4664-5

Spacer

**

SAD 14/01/27

Location

Loc Qty

Loc Code

prelim

64

111711

64

D4732-17

Manufactured No

100 Each

21.0000

1

1

D4732-17

Label

**

SAD 14/01/28

Location

Loc Qty

Loc Code

ST122

21

111247

16

93378

5

D4732-23

Manufactured No

100 Each

21.0000

1

1

D4732-23

Label

**

SAD 14/01/28

Location

Loc Qty

Loc Code

ST122

21

111250

16

93280

5

• **Ricklist Print**

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Work Order ID: 111863

111863

Parent Item: D4634-145

D4634-145

Parent Item Name: Aft, Center Ceiling Replacement Panel Assembly

Start Date: 1/23/2014

Required Date: 1/29/2014

Start Qty: 1.00

Required Qty: 1.00

D4732-27

Manufactured No

100

Each

23.0000

1

1

D4732-27

Label

SAD 14/01/28

Location

Loc Qty

Loc Code

ST122

23

111252

15

93195

8

MPNY-750S-9-C

Purchased

No

100

Each

957.0000

9

9

MPNY-750S-9-C

Mounting Pad

SAD 14/01/28

Location

Loc Qty

Loc Code

ST390

957

124058

1

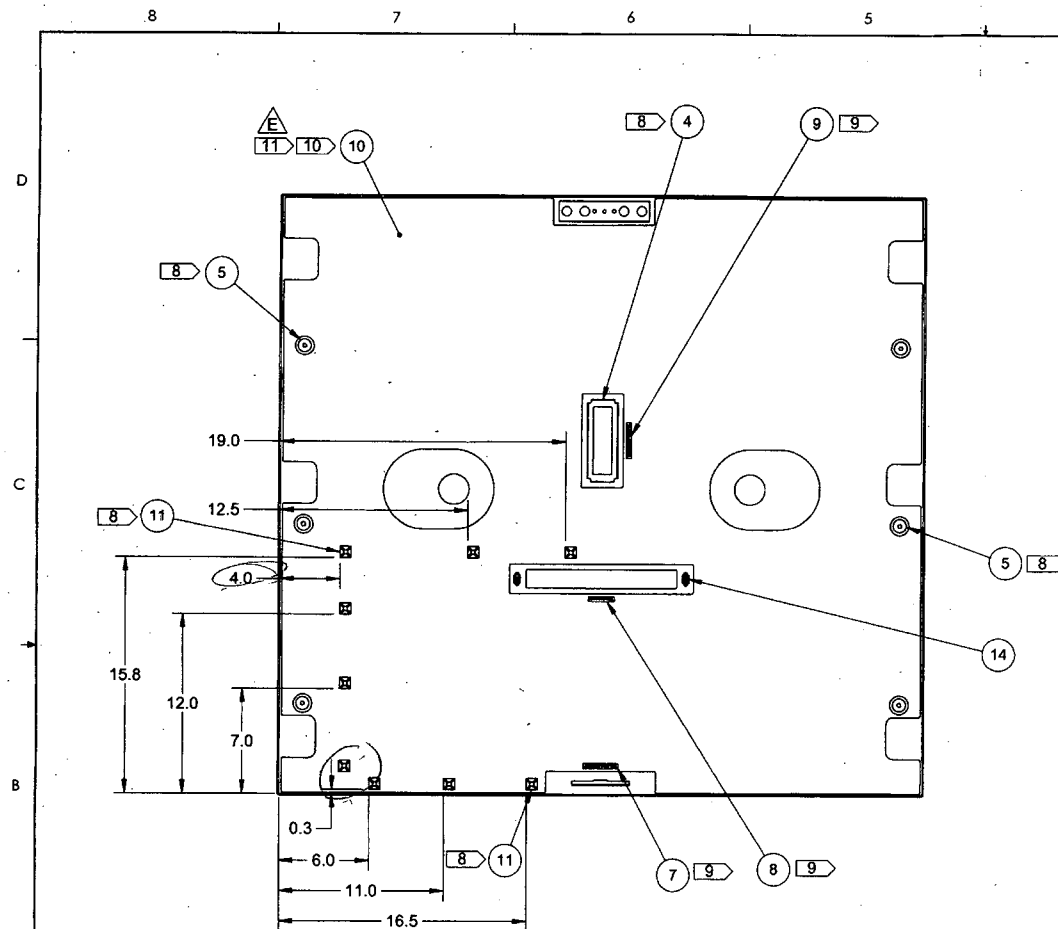
M127960

956

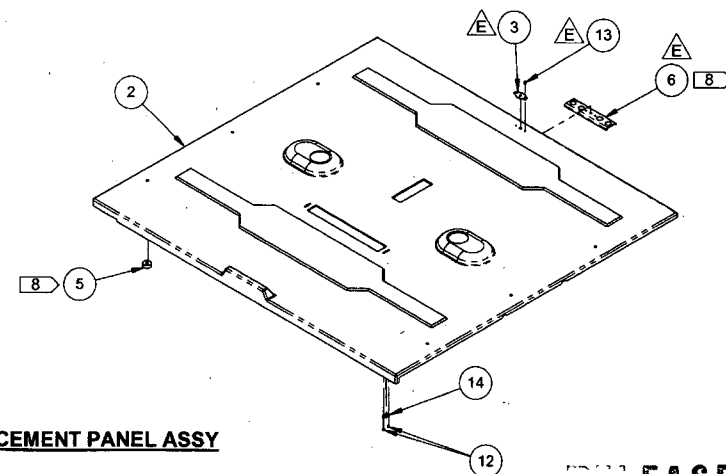
9

111863 RHT-01-23

ITEM NO.	QTY. -145	PART NUMBER	DESCRIPTION
1	X	D4634-145	AFT, CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-5	AFT, CENTER CEILING PANEL
3	1	D4636-5	BRACKET
4	1	D4647-1	DOUBLER
5	6	D4664-5	SPACER
6	1	D4712-1	BRACKET
7	1	D4732-17	LABEL
8	1	D4732-23	LABEL
9	1	D4732-27	LABEL
10	1	D5021-5	FOAM, CENTER PANEL, AFT
11	9	MPNY-750S-9-C	MOUNTING PAD
12	4	MS20426AD3-(4)	RIVET
13	2	MS20426AD4-(6)	RIVET
14	2	MS21059L08	ANCHOR NUT



D4634-145 AFT, CENTER CEILING REPLACEMENT PANEL ASSY



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4647-1 & MPNY-750S-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE.
LOCATE D4647-1 IN LINE WITH RECTANGULAR OPENING
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5021-5 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5021-5 FOAM ON D4634-5

RELEASED
2014-01-22

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. E
MFG. APPR.	BC	D4634	SHEET 9 OF 17
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	CENTER CEILING PANELS	NTS
DATE	14.01.09	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	